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Ship Today

DSI 9775-011
Job Sheet 183109



Part No: DSI 9775-011

Job Qty: 1 ea

Part Name: Skidtube Doubler Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev. A New issue JFS 17/04/05 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/12/18	9/12/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 12 2018
110	Packaging	1 pcs	9/12/18	9/12/18	0.00	0.00	Packaging1-5		SEP 12 2018
120	QC	1 pcs	9/12/18	9/12/18	0.00	0.00	QC4		SEP 12 2018
130	Packaging	1 pcs	9/12/18	9/12/18	0.00	0.00	Packaging3-2		SEP 12 2018
135	DC	1 pcs	9/12/18	9/12/18	0.00	0.00	DC		SEP 12 2018
140	QC21-FG	1 Ea	9/12/18	9/12/18	0.00	0.00	QC21		SEP 12 2018

Part Op 130 - Identify and pack for shipping as per PPP DSI 9775-011 Location: FG123
Descriptions: 135 - Photocopy bluefile & type labels per PPP DSI 9775-011 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3524-5-3	Rivet, Countersunk	160 Ea (160 ea)	90-Start up Operation	5035966
D5514-1	Doubler	4 Ea (4 ea)	90-Start up Operation	5063622
D5517-1	Ground Handling Pin	4 Ea (4 ea)	90-Start up Operation	5075072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3524-5-3	160	440	0
	D5514-1	4	10	0
	D5517-1	4	4	0

Part Specifications



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could not be found.

Plex 9/12/18 1:07 PM Dart.lajeunesse.marie

Container No: S109635



Part: DSI 9775-011

Job No: 183109

Serial No/Batch: S109635

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 10, FAA STC SH967NE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under toleranc ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Change Record

PAGE 1 OF 1

Part Number: DSI 9775-011

Description: SKIDTUBE DOUBLER INSTALLATION[illegible]

- 2.9 Apply a 0.010" (0.3mm) thick layer of Proseal 890 B1/2 or Proseal 1422 B1/2 to the inner surface of one doubler.
- 2.10 Using cleco clamps, secure the doubler onto one side of the skidtube.
- 2.11 Liberally coat the shoulder on one end of each pin with Proseal 890 B1/2 or Proseal 1422 B1/2 and insert that end through the skidtube into the doubler.
- 2.12 Liberally coat the shoulder on the other end of the pins with Proseal 890 B1/2 or Proseal 1422 B1/2.
- 2.13 Apply a 0.010" (0.3mm) thick layer of Proseal 890 B1/2 or Proseal 1422 B1/2 to the inner surface of the second doubler.
- 2.14 Using cleco clamps, secure the second doubler onto the other side of the skidtube.
- 2.15 Ensure that both doublers are flush against the surface of the skidtube.
- 2.16 Ensure that the doublers and pins remain properly aligned per Figure 2 of this service instruction.
- 2.17 Using CR3524-5-3 Rivets, secure both doublers to the skidtube. Reference Figure 3 of this service instruction
- 2.18 Remove all excess Proseal.
- 2.19 Relocate the float hose support brackets if necessary.
- 2.20 Reinstall the modified skidtube onto the aircraft per ICA-D117-762 Chapter 32.2 / 32.8 / 32.10.
- 2.21 Repeat steps 2.1 thru 2.20 on the other skidtube.
- 2.22 Update the aircraft log book as applicable to indicate installation of the DSI 9775-011 Skidtube Doubler Kit.

3.0 PARTS LIST

The DSI 9775-011 Skidtube Doubler Kit contains the parts required to modify Qty (2) skidtubes.

*Qty (8) additional rivets are provided with the kit.

Qty -011	Part Number	Description
X	DSI 9775-011	SKIDTUBE DOUBLER
4	D5514-1	DOUBLER
4	D5517-1	GROUND HANDLING PIN
*160	CR3524-5-3	RIVET, COUNTERSUNK

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

When the DSI 9775-011 Skidtube Doubler Kit is installed on both skidtubes, there is a net weight increase as stated in the following table.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9775-011 SKIDTUBE DOUBLER KIT	2.2 lb 1.0 kg	0 in 0 m	0 in-lb 0 m-kg	180 in 4.6 m	396 in-lb 4.6 m-kg

APPROVED

DESIGN	ML	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9775	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE DOUBLER	NTS
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